

Work Order ID 92236-2
Tuesday, October 23, 2012 4:13:41 PM

(3)

92236

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Item ID: PB67-43001-01
Revision ID:
Item Name: Fwd Blade Fold Assembly
Start Date: 10/23/2012 Start Qty: 2.00
Required Date: 11/30/2012 Req'd Qty: 2.00
Reference:

Accept
2
2

N9000040100 Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: MJS
QC:

Date: 12-10-25 Tooling:
Date: SPC (Y/N):

Run Start *NR1*
Date: Stop *NR2*
Date:

Sequence ID/
Work Center ID
Draw Nbr
B67-43001-01
100
100
Small Fab
Small Fab

Operation
Description
Revision Nbr
Rev C

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

0.00

0.00

Memo

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock
Blue

A/R shown on dwg PB67-43001 page 2.

12/12/12 242 THREADLOCK Blue batch: M12C 367
A/R touch up paint with sandflex green
batch: 14123885

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(DAS 15)

12/12/12

CP/12 CP/12.12.19

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Item ID: PB67-43001-01

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Blade Fold Assembly

Stop *NS2*

Start Date: 10/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/30/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Memo

0.00

Packaging

12/12/19



130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS 12-12-19

U 12-12-19

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec
EC verified by:DD IPP RevC 10.09.24 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS51859-7 Washer		Purchased	No				Each	36.0000		8	✓		JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST295		20							
				122141		20				7 X 122141			
				ST296		16							
				111193		6							
				120518		10				1 X 120518			
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	159.0000	8	16	✓		JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				122089		81							
				122089		81				122089			
				ST400		78							
				115827		78							
30345122 8" LANYARD		Purchased	No			100	Each	16.0000	2	4	✓		JB
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		16							
				112853		16				112853			
30345124 LANYARDS		Purchased	No			100	Each	37.0000	2	4	✓		JB 12/11/06
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		37							
				112853		37				112853			

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-10A

Bolt

Purchased

No

100

Each

94.0000

2

4

✓

JB

Location

Loc Qty

Loc Code

ST355

50

122407

50

ST356

44

117619

4

122800

40

122800

AN4-13A

Bolt

Purchased

No

100

Each

916.0000

2

4

✓

JB

Location

Loc Qty

Loc Code

ST356

803

122416

281

122808

22

122993

500

ST357

113

120187

19

120770

12

121652

81

122063

1

122416

AN4-15A

Bolt

Purchased

No

100

Each

404.0000

4

8

✓

JB

12/11/06

Location

Loc Qty

Loc Code

GA

100

120449

100

ST357

287

122800

87

123021

200

ST358

17

118706

3

120422

1

122141

13

123021

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

AN6-11A BOLT	Purchased	No		100	Each	65.0000	2	4	JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST341	65					
			111177	15	111177				
			114437	50					
AN6-20A Bolt	Purchased	No		100	Each	29.0000	2	4	JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST339	20					
			122416	20	122416				
			ST341	9					
			118706	9					
AN8-13A BOLT	Purchased	No		100	Each	10.0000	2	4	JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST343	10					
			110915	10	2x 110915				
				100	Each	39.0000	4	8	JB
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST284	39					
			110704	36	110704				
			111127	3					
CR3213-4-05 cherry rivet	Purchased	No		100	Each	738.0000	2	4	JB 12/11/06
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST328	600					
			123301	600					
			ST331	138					
			108473	38					
			108991	100	108991				

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

D3445-041
Belt Assembly

Manufactured No

100 Each 3.0000

1 1792251 2 JB

Location

Loc Qty

Loc Code

ST440

3

52615

3

D3447-3

Square Spacer

Manufactured No

100 Each 3.0000

1 1752612 2 92252 JB

Location

Loc Qty

Loc Code

ST440

3

58012

3

D3447-7

Clevis

Manufactured No

100 Each 4.0000

2 90931 JB

Location

Loc Qty

Loc Code

ST440

4

52665

4

D3447-9

Swing Arm

Manufactured No

100 Each 4.0000

2 92253 JB

Location

Loc Qty

Loc Code

ST440

4

62127

4

D3451-041

Handle and Lock-Down Assembly

Manufactured No

100 Each 0.0000

1 2 1112.12.12

D3451-047

Handle and Lock-Down Assembly

Manufactured No

100 Each 0.0000

1 2 72262

D3922-1

Clip

Manufactured No

100 Each 39.0000

2 4 JB 12/11/00

Location

Loc Qty

Loc Code

st073

39

66852

39

66852

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

MS17984-C408

Purchased

No

100

Each

5.0000

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST314

5

112940

5

MS17984-C418

Purchased

No

100

Each

15.0000

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

15

114416

2

114523

13

MS210421.3

Purchased

No

100

Each

3,172.0000

Nut

Location

Loc Qty

Loc Code

316

627

122452

627

ST300

338

117885

32

119017

168

119075

138

ST314

1781

123265

1781

ST317

426

122141

426

2 123482 4 JB

2 2123482 4 JB

2 2114523 4

JB 12/11/06

123265

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

MS210421.4

Nut

Purchased

No

100

Each

6.806.0000

8

16

✓

JB

Location

Loc Qty

Loc Code

314

1279

122452

1279

ST300

27

119017

20

121444

7

ST314

5500

123021

3000

123248

900

123355

1600

123021

MS210421.6

Nut

Purchased

No

100

Each

1.093.0000

4

8

✓

JB

12/11/06

Location

Loc Qty

Loc Code

314

314

122441

314

ST300

279

117677

25

118384

3

118927

48

119075

4

120308

199

ST314

500

123248

350

123355

150

122441

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-04

Purchased

No

100

Each

3,498.0000

2

4

SCREW

Location

Loc Qty

Loc Code

ST291

298

119638

3

120142

94

120910

1

121476

200

ST305

3200

122815

3200

MS27039-1-21

Purchased

No

100

Each

198.0000

2

4

SCREW

Location

Loc Qty

Loc Code

ST291

100

115935

100

ST292

98

115935

98

MS51859-6

Purchased

No

100

Each

96.0000

4

8

WASHER

Location

Loc Qty

Loc Code

ST296

96

111279

8

112940

88

MS51859-8

Purchased

No

100

Each

28.0000

8

WASHER

Location

Loc Qty

Loc Code

ST296

28

112940

28

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN632J

Washer

Purchased

No

100

Each

144.0000

6

12

✓ JB

Location

Loc Qty

Loc Code

298

130

122441

130

122441

ST298

14

118428

14

NAS1149F0316P

WASHER

Purchased

No

100

Each

233.0000

4

8

✓ JB

Location

Loc Qty

Loc Code

ST275

233

112940

33

112940

113237

100

113644

100

NAS1149F0432P

Washer

Purchased

No

100

Each

672.0000

16

32

✓ JB

Location

Loc Qty

Loc Code

275

588

122441

588

122441

ST275

84

121350

15

122151

69

NAS1149F0632P

WASHER

Purchased

No

100

Each

447.0000

8

16

✓ JB

Location

Loc Qty

Loc Code

ST275

447

18057

447

18057

NAS1149F0832P

WASHER

Purchased

No

100

Each

244.0000

2

4

✓ JB

Location

Loc Qty

Loc Code

ST275

244

18057

244

18057

12/11/06

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

NAS43DD3-68

SPACER

Purchased

No

100

Each

24.0000

2

4

JB

Location

Loc Qty

Loc Code

ST278

1

112410

1

ST279

23

120142

23

120142

*

PB67-43001-07

Fwd Blade Fold Assembly Weldment

Manufactured

No

B92211

100

Each

0.0000

1

2

92211

PB67-43001-11

Fwd Adjustable Blade Support Assembly

Manufactured

No

100

Each

0.0000

1

2

92120

*

PB67-43001-15

Fwd Adjustable Blade Support Assembly

Manufactured

No

B92118

100

Each

0.0000

1

2

110.10.12

PB67-43001-21

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

2

92114

PB67-43001-23

PB67-43001-23

Manufactured

No

B92113 = (2)

100

Each

0.0000

1

2

110.10.12

PB67-43001-261

Lever Arm

Manufactured

No

100

Each

8.0000

2

4

11 52493 JB
4 90931

Location

Loc Qty

Loc Code

ST432

8

62182

8

PB67-43001-265

Deltin Bushing

Manufactured

No

100

Each

14.0000

4

8

90932 JB

12/11/06

Location

Loc Qty

Loc Code

ST438

2

40056

2

WA

12

85184

12

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Work Order ID: 92236

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 10/23/2012

Required Date: 11/30/2012

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-299

Manufactured No

100

Each

13.0000

2

4

Bushing

Location

Loc Qty

Loc Code

ST439A

13

44969

13

PB67-43001-45

Manufactured No

100

Each

0.0000

1

2

Longitudinal Support

PB67-43001-51

Manufactured No

100

Each

0.0000

1

Long T-Handle Assembly

44969

92107

92107

JB

JB

12/1/06

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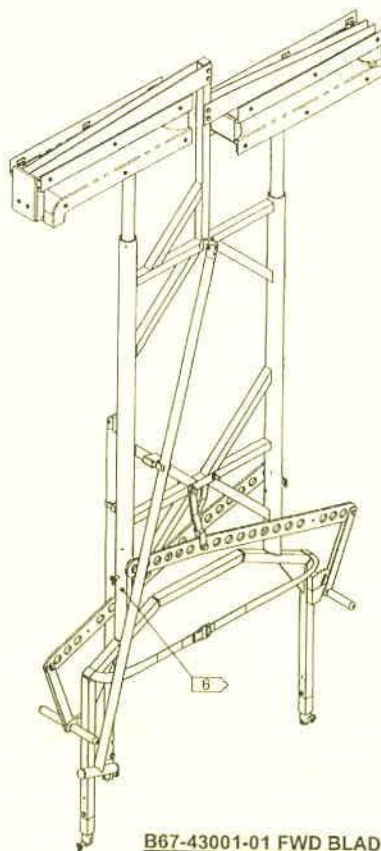
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ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG I-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELFIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN8-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-05	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL Ø0.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING)
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOWN. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

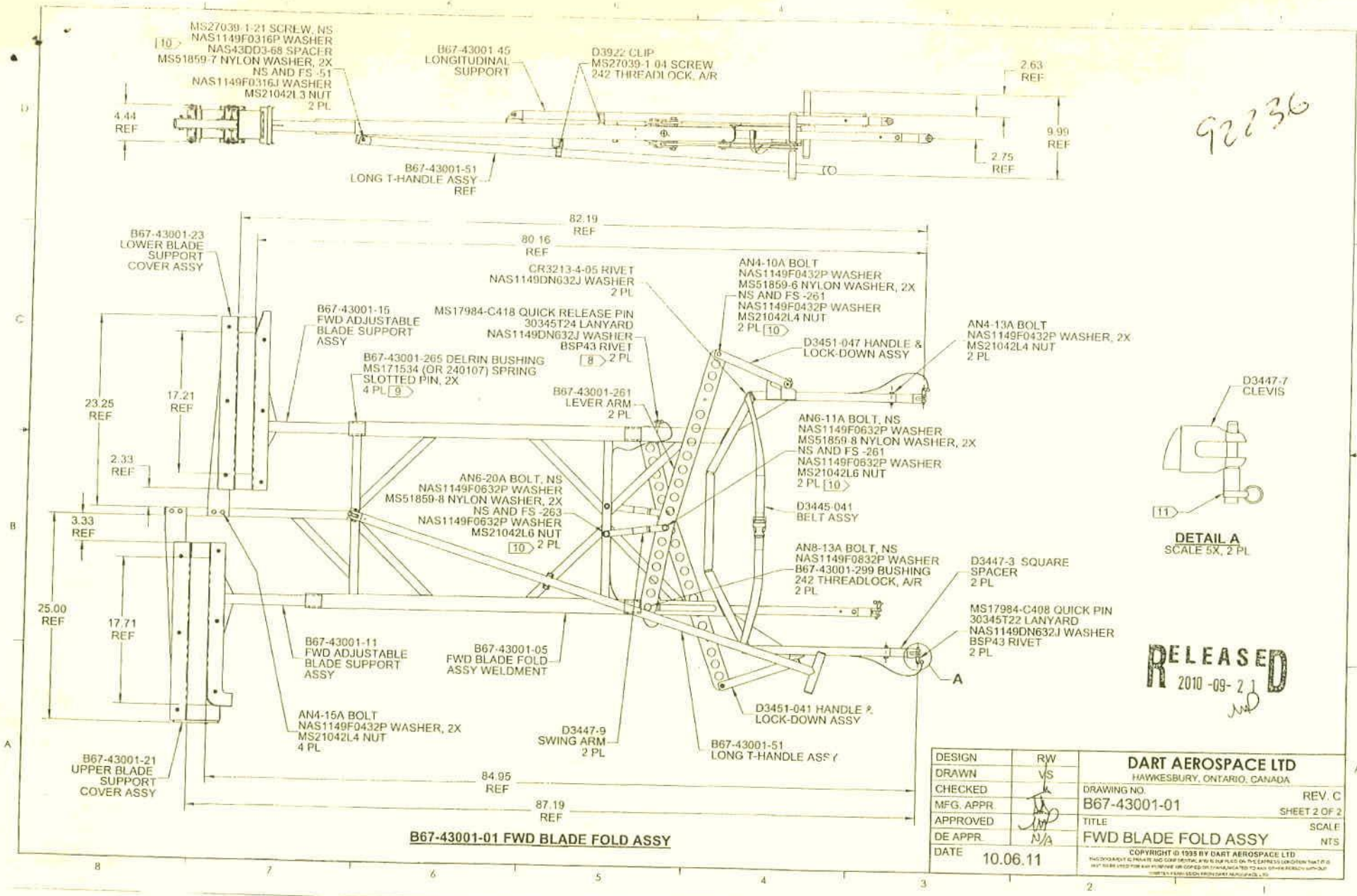
92236 MJS
12-10-25

RELEASED
2010-09-21

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011	VS	10.06.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-01	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	VA	FWD BLADE FOLD ASSY	NTS	
DATE	10.06.11			

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92236



DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR		B67-43001-01	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR		FWD BLADE FOLD ASSY	NTS
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